

Date: Monday, 11/19/2007 4:04:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STOP
Job Number : 35852	
Estimate Number : 10514	
P.O. Number : <i>N/A</i>	Part Number : D28051
This Issue : 11/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2805 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 34273	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/5/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
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Comment: Qty.: 0.2756 f(s)/Unit Total: 5.5125 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: *M102723X/16705**M16954X/425 J.L 07/11/23*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

J.L 07/11/23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-1

8F 07/12/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8F 07/12/12

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/12/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2805-1 PAR #: N/A Fault Category: Prod / machined ^{parts} NCR: (Yes) No DQA: D Date: 07/12/14
 QA: N/C Closed: HJ Date: 07.12.14

NCR: <u>35852</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/12	3.0	Took wrong Z origin forger .125" in positif so the part is too short. R.C operator error	<i>[Signature]</i> 06/10/12	Scrap and Destroy and Replace	<i>S.F.</i> 07/12/12	<i>[Signature]</i> 07/12/12	<i>[Signature]</i> 06/10/12	<i>[Signature]</i> 07/12/12
07/12/12	3.0	1 part is too short by 0.001" R.C Material is cut too short.	<i>[Signature]</i> 06/10/12	Test fitted part into the bracket. Fit is very good. part acceptable.	<i>S.F.</i> 07/12/12	<i>[Signature]</i> 07-12-12	<i>[Signature]</i> 06/10/12	<i>[Signature]</i> 07-12-12
07/12/12	3.0	1 part is too short By .124 R.C Material is cut too short. + human error	<i>[Signature]</i> 06/10/12	Remove material to check Block prior to machine Scrap / destroy / replace	<i>S.F.</i> 07/12/12	<i>[Signature]</i> 07/12/12	<i>[Signature]</i> 06/10/12	<i>[Signature]</i> 07/12/12

NOTE: Date & initial all entries

error

Date: Monday, 11/19/2007 4:04:10 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 35852

Part Number: D28051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 07-12-13

X20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

07/12/13 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 47

AS 07/12/13

X20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/14

Job Completion



07.12.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35852
Description: Stop		Part Number:	D2805-1
Inspection Dwg: D2805 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.975	✓			
0.240	+/-0.010	.236	✓			
0.100 chamfer	+/-0.010	.100	✓			
1.420	+/-0.001	1.420	✓	1		
1.125	+/-0.010	1.130	✓			
0.250	+0.005/-0.000	.250	✓			
0.250	+/-0.010	.254	✓			
1.500	+/-0.010	1.500	✓			
1.000	+/-0.010	.997	✓			
0.875	+0.001/-0.000	.875	✓			
0.438	+0.001/-0.000	.438	✓			
Ø0.191	+0.005/-0.000	.194	✓			
2.689	+/-0.010	2.689	✓			

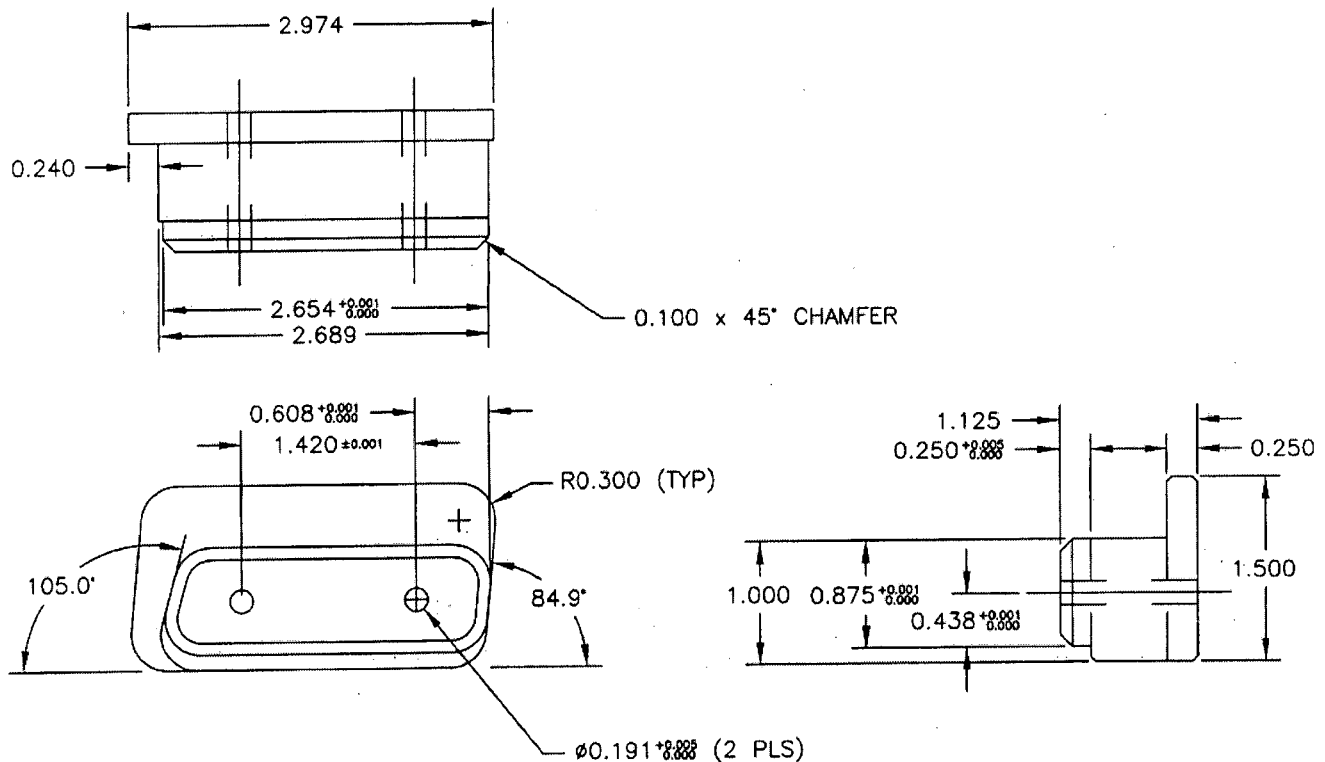
Measured by: <u>LF</u>	Audited by: <u>J.L</u>	Prototype Approval:	N/A
Date: <u>07/11/12</u>	Date: <u>07/12/12</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	<u>BE</u>



DESIGN #	DRAWN BY LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35852

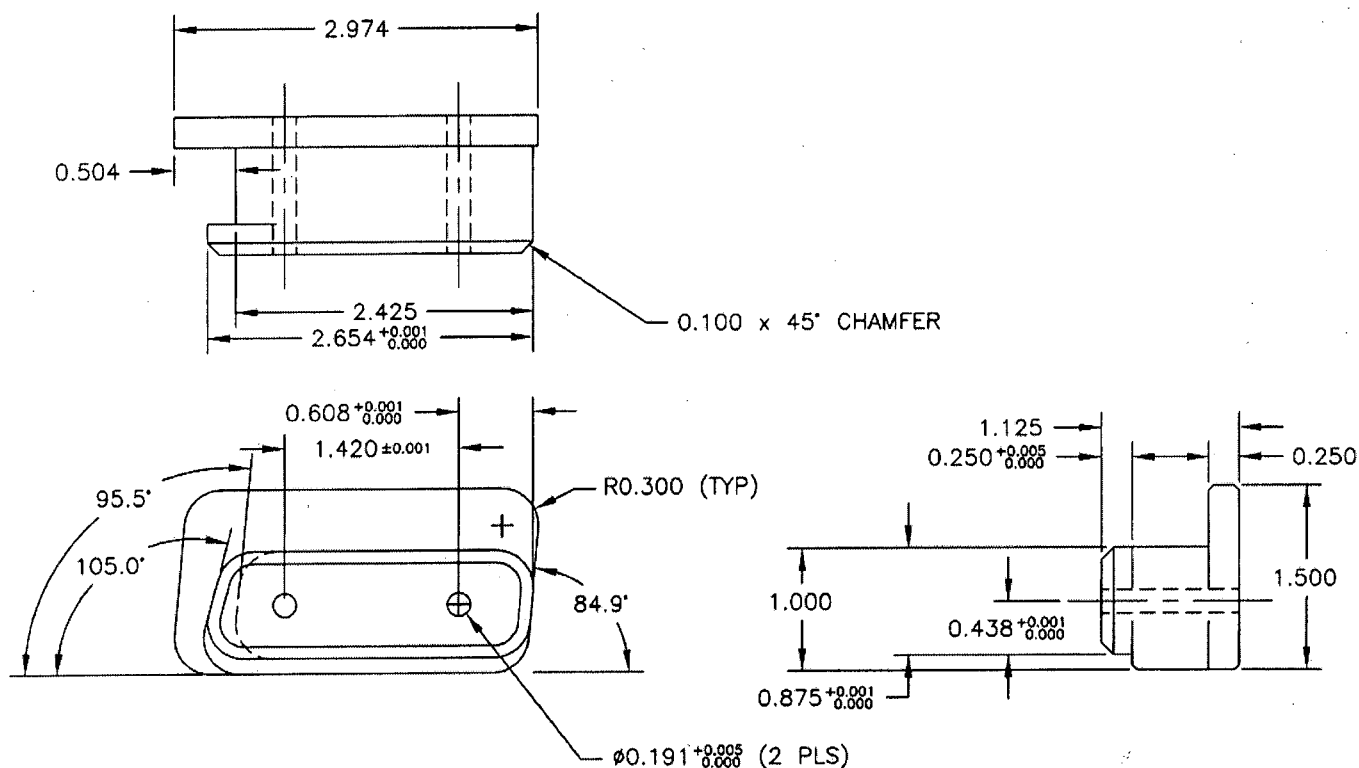
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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